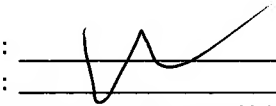
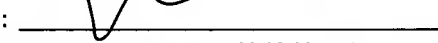


Date: Tuesday, 18/12/2007 1:53:19 PM
 User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	BLOWER MOTOR INLET ADAPTER
Job Number :	36432		
Estimate Number :	12247		
P.O. Number :		Part Number :	D3477041
This Issue :	18/12/2007	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3477 UNDER REVIEW
First Issue :	/ /	Project Number :	N/A
Previous Run :	31258	Drawing Revision :	A
Written By :		Material :	
Checked & Approved By :		Due Date :	25/12/2007
Comment :	Est Rev: A New Issue 06-02-03 JLM		

Qty: 4 **Um:** Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	D34773	Tube
-----	--------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3477-3	Tube	B 36352

MF

2.0	D34771	Flange
-----	--------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3477-1	Flange	B 34398

MF

3.0	D34775	BLOWER ADAPTER FLANGE
-----	--------	-----------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3477-5	Flange	B 34399

MF

07-12-20

4.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per Dwg D3477

2-Spot Weld as per Dwg D3477 and Dart QSI 004

MF

07-12-20

(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 18/12/2007 1:53:19 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLOWER MOTOR INLET ADAPTER

Job Number: 36432

Part Number: D3477041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC11

VISUAL INSPECTION OF SPOT WELDING



Comment: VISUAL INSPECTION OF SPOT WELDING

SB 07/12/19

(4)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/12/19

(4)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with a permanent fine point marker and Stock

Location: GA

mf 07-12-19

(4)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mi 2007/12/19 (4) CY

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3477	REV. A SHEET 1 OF 4
DATE 05.12.09		TITLE BLOWER INLET ADAPTER	SCALE 1:2
A	05.12.09	NEW ISSUE	

*06.04.03***UNDER REVIEW**

02.09.03
Dim + alignment
Chassis

D3477-5 BLOWER
ADAPTER FLANGE (1)D3477-3
TUBE (1)D3477-1
FLANGE (1)ALIGNMENT OF
SPOT WELD SEAM $\phi 7.13$
(REF)

30°

45°

30°

(2 PLACES)

0.50
(24)

2.04

D3477-041 BLOWER MOTOR INLET ADAPTER**NOTES:**

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) IDENTIFY WITH DART P/N D3477-041 USING FINE POINT PERMANENT INK MARKER
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -041	P/N	DESCRIPTION
X	D3477-041	BLOWER MOTOR ASSEMBLY
1	D3477-1	FLANGE
1	D3477-3	TUBE
1	D3477-5	BLOWER ADAPTER FLANGE

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

SPOT WELD TEST RECORD
AMS-W-6858A
CLASS 'C'

TEST NO#: 5

EMPLOYEE: Melanie Fautsch

PART NUMBER: D3477-041

JOB NUMBER: B 36432

MATERIAL TYPE: 304 L

MATERIAL THICKNESS: .018

GROUP SPECIFICATION

☐

Group 1: Aluminum & magnesium

☐

Group 2: Iron; nickel; cobalt

☒

Group 3: Titanium SS

TEST RESULTS

	PASS	FAIL	
VISUAL:	[<input checked="" type="checkbox"/>]	[<input type="checkbox"/>]	
PENETRATION:	[<input checked="" type="checkbox"/>]	[<input type="checkbox"/>]	
PULL STRENGTH:	[<input checked="" type="checkbox"/>]	[<input type="checkbox"/>]	PSI Reading: _____

Qualified in accordance with standard AMS-W-6858A and QSI 004 (ref: 4.3)

DATE OF TEST COUPON: 07/12/19
QUALIFIER: S/S